

Date: Tuesday, 4/25/2006 8:36:45 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE		
Job Number	: 26816					
Estimate Number	: 11175					
P.O. Number	: N/A			Part Number	: D22825	
This Issue	: 4/25/2006 S.O. No. : N/A			Drawing Number	: D2282 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: E	
Previous Run	: 25134			Material	: N/A	
Written By	<i>Serg</i> <i>Comment Below</i>			Due Date	: 5/20/2006	
Checked & Approved By	<i>Off 06.04.25</i>			Qty:	100	Um: Each
Comment	: Est Rev:A			Removed from 9 Digit	05-12-02 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R0750	Inventory	
		Comment: Qty.: 0.1891 f(s)/Unit Total : 18.9063 f(s) Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch <u>M18553</u>	<i>MS 06/06/03</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL  1-Turn as per Dwg D2282 and Folio FA189	
	2-Deburr		<i>J. G 06/06/03 100</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>J. G 06/06/03 100</i>
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Mill Arc as per Dwg D2282	<i>HAAS CNC Vertical Machining J.F. 06/06/05 100</i>
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>J.F. 06/06/05 100</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 06.06.04

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 36

AV 6/6/5

100

8.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/06

Job Completion



u done

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26816
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282	Rev: E	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	J. G.	Audited by:	J.F.	Prototype Approval:	N/A
Date:	06/06/03	Date:	06/06/04	Date:	N/A

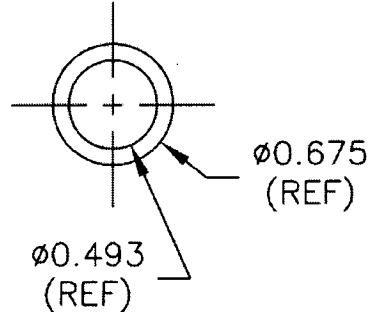
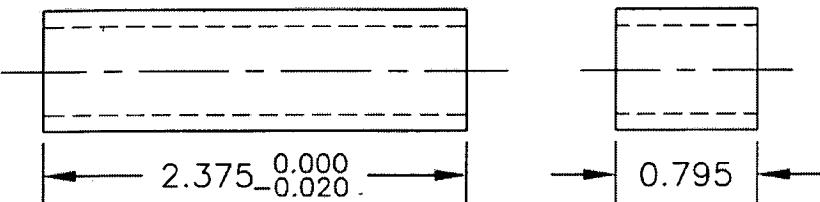
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	✓ <i>[Signature]</i>



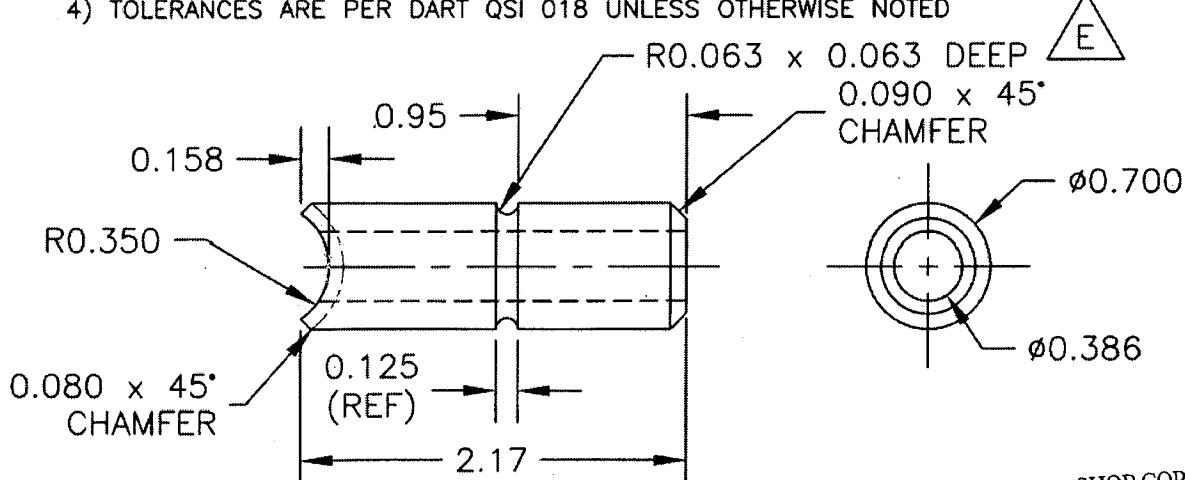
**DART**

DESIGN BW	DRAWN BY <i>BP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282
DATE 05.06.07	TITLE HANDLE TUBES	REV. E SHEET 1 OF 2
		SCALE 1:1

**RELEASED**  
BS/09/16

**D2282-3****D2282-7****D2282-3/7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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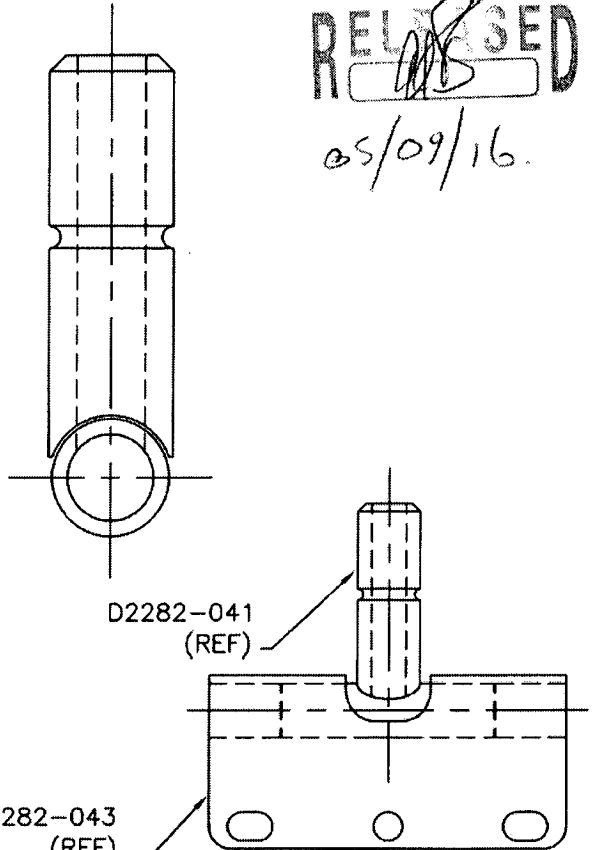
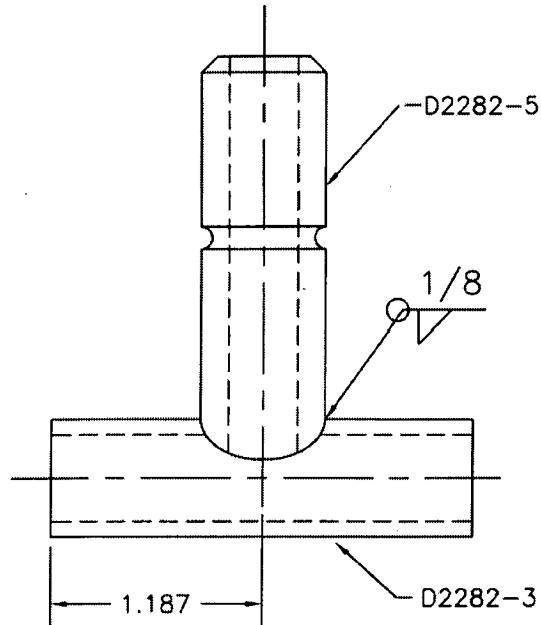
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WORK ORDER  
NO. *26816*

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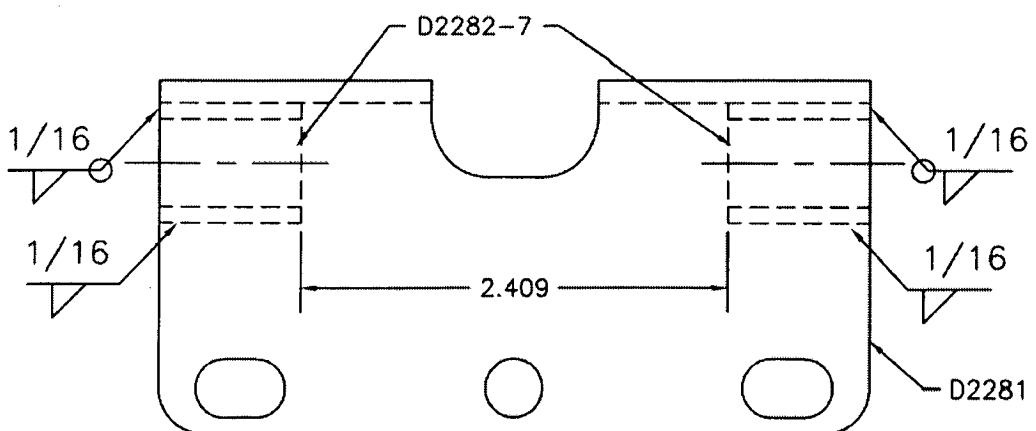
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**DART**

DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>UP</i>	APPROVED <i>MLB</i>	DRAWING NO. D2282 REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES SCALE 1:1



**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

**GENERAL ASSEMBLY**  
SCALE 1:2

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